

Date: Friday, 09/05/2008 1:45:40 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR AFT RH		
Job Number	: 39162			Part Number	: D32814		
Estimate Number	: 11235			Drawing Number	: D3281 REV. D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 09/05/2008	S.O. No.	:	Drawing Revision	: D		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 16/05/2008		
Previous Run	: 37891			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08.509</u>						
Comment	: Est Rev A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Ext. Rev C. 08.02.06 to reflect updated Dwg. DL Est. Rev D. 08.04.15 Material Change DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET	
Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s) GE PLASTICS LEXAN SHEET			
Material Batch Number <u>H 106751</u>			
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
1) Cut Blanks <u>B 08/05/15 x 10</u>			
3.0	THERMOFORMING	THERMOFORMING MACHINE	
Comment: THERMOFORMING MACHINE			
Thermoform as per Dwg. D32811 and Folio FTA 010			
Dwg. Rev. <u>B</u> Folio Rev. <u>B</u> <u>B 08/05/15 x 10</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 08/05/20x0</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:45:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT RH

Job Number: 39162

Part Number: D32814

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/05/20 X10

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

BB 08/05/20 X10

2) Check dimensions to ensure conformity to drawing tolerances.

7.0 QC5

INSPECT WORK TO CURRENT STEP



BB 08/05/20 X10

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/5/21

SCC
100%

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2021

Job Completion



MF 08-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39162
Description: Floor Protector, Aft RH	Part Number:	D3281-4
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: BB Date: 08/05/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.8	✓			
17.1	+/-0.100	17.12	✓			
14.3	+/-0.100	14.3	✓			
0.95	+/-0.030	.965	✓			
0.25	+/-0.030	.243	✓			
3.1	+/-0.100	3.1	✓			
0.050	Min	.065	✓			
0.070	Min	.071	✓			

Measured by: BB Date: 08/05/20

Audited by: BB Date: 08/05/20

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	<u>BB</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

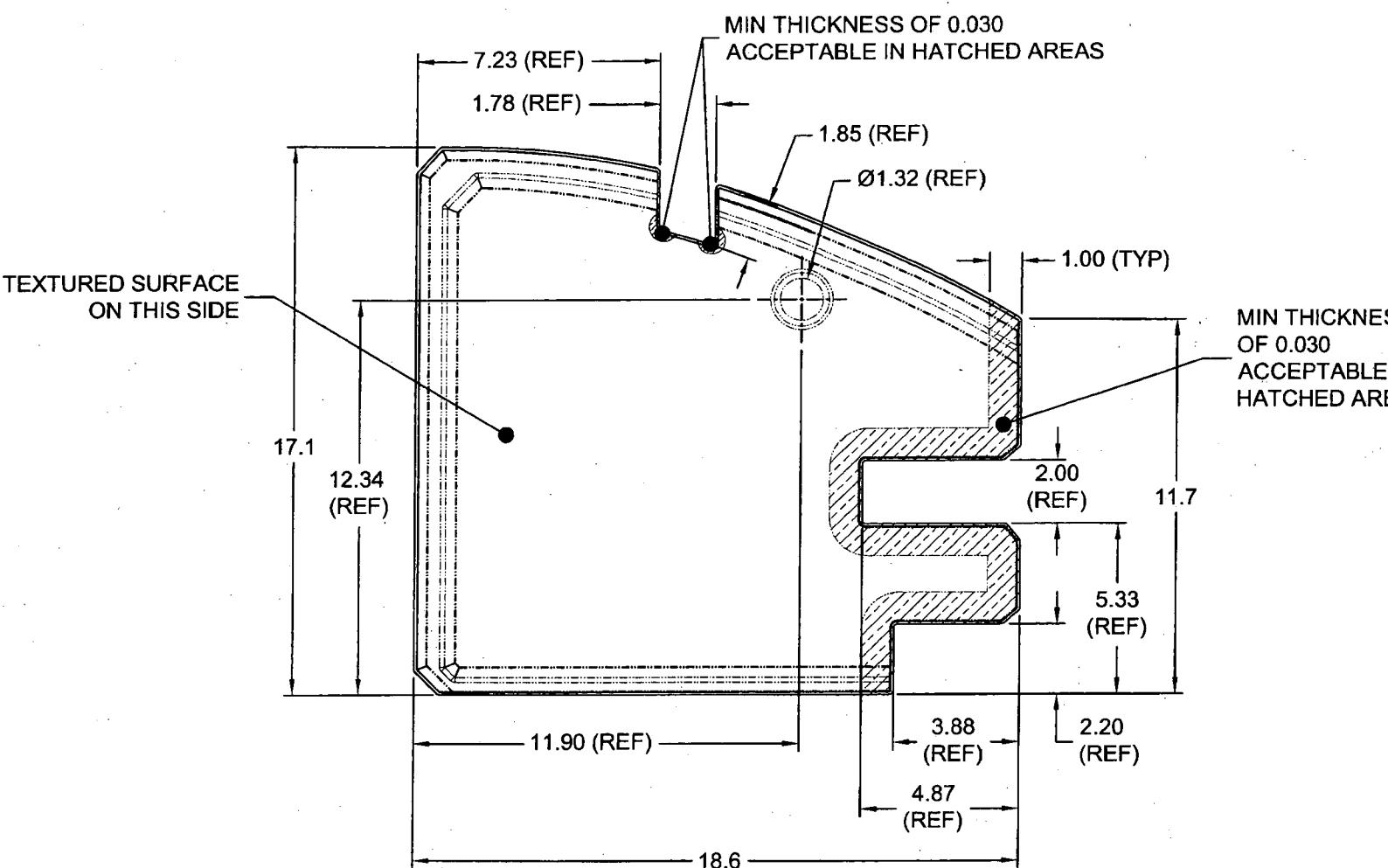
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 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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D3281-1 FLOOR PROTECTOR

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

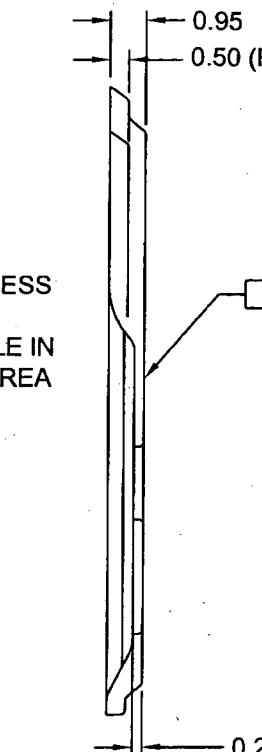
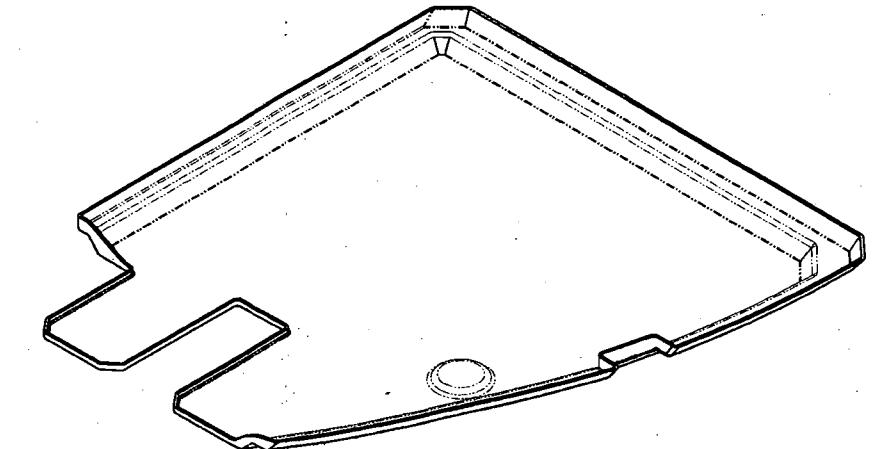
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NO. 39162

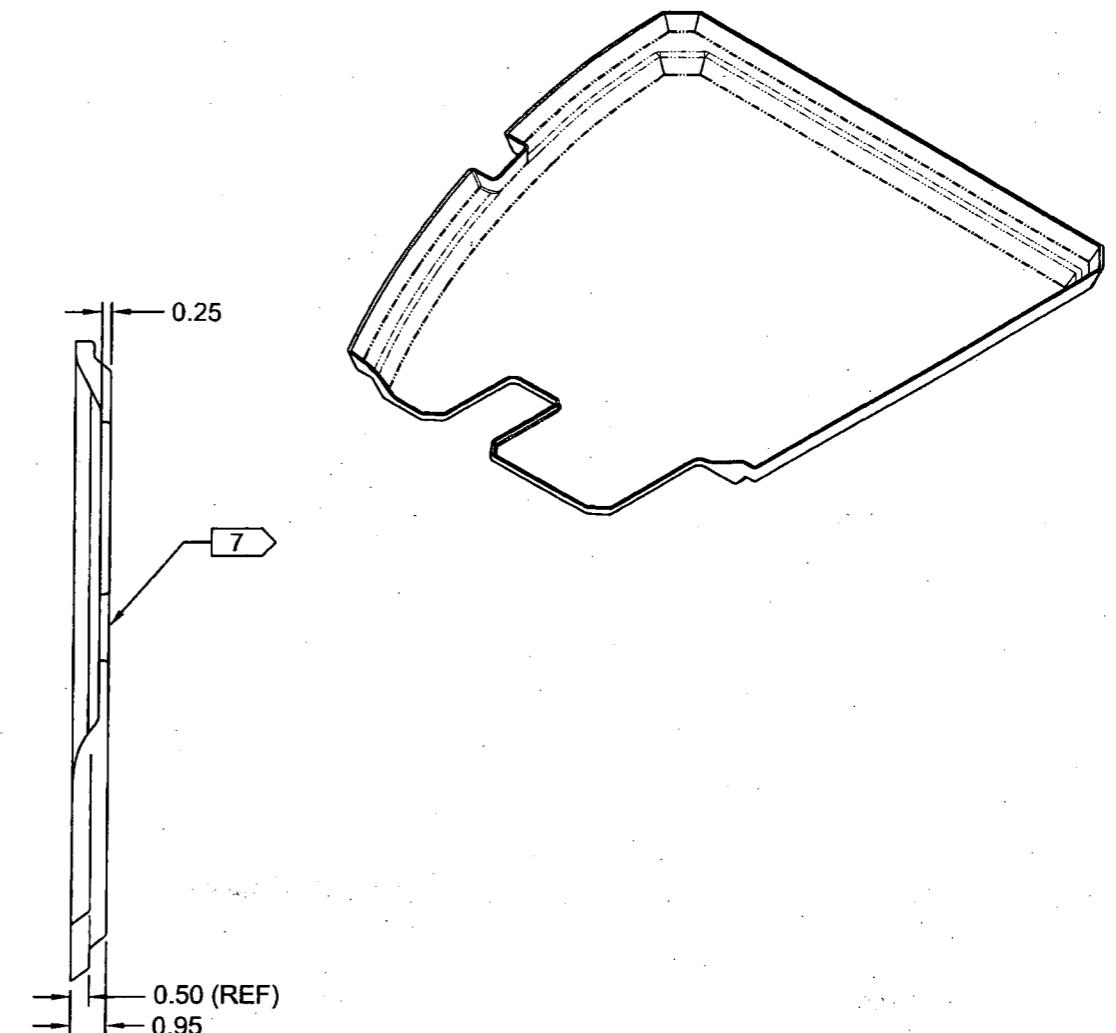
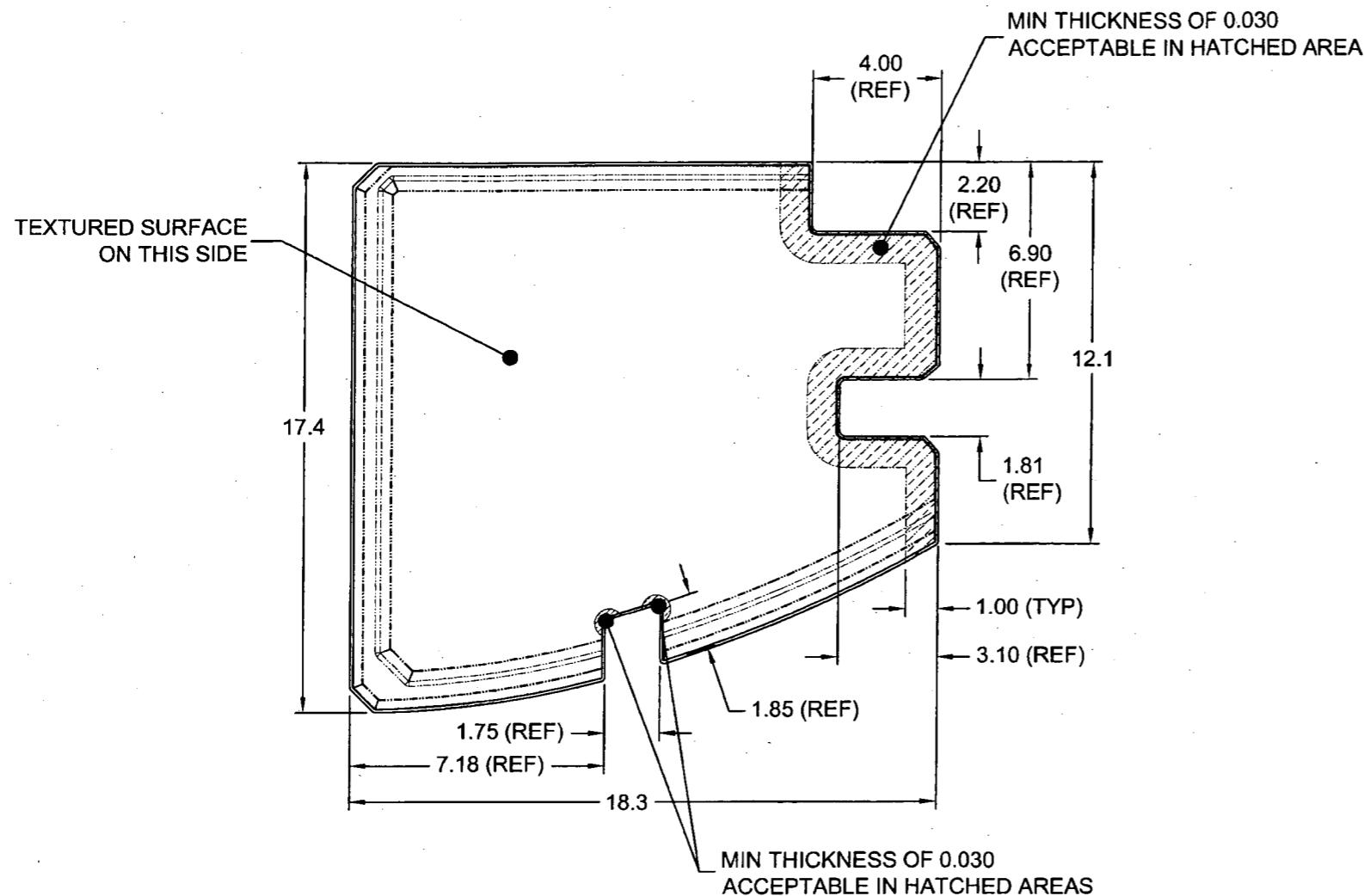
RELEASED
05.04.11 WD

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	RE		
CHECKED	3		
MFG. APPR.	DP		
APPROVED	JP		
DE APPR.	CH		
DATE	08.03.28		
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. D
		D3281	SHEET 1 OF 4
		TITLE	SCALE
		FLOOR PROTECTOR	NTS
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RELEASER
08/11/04

D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

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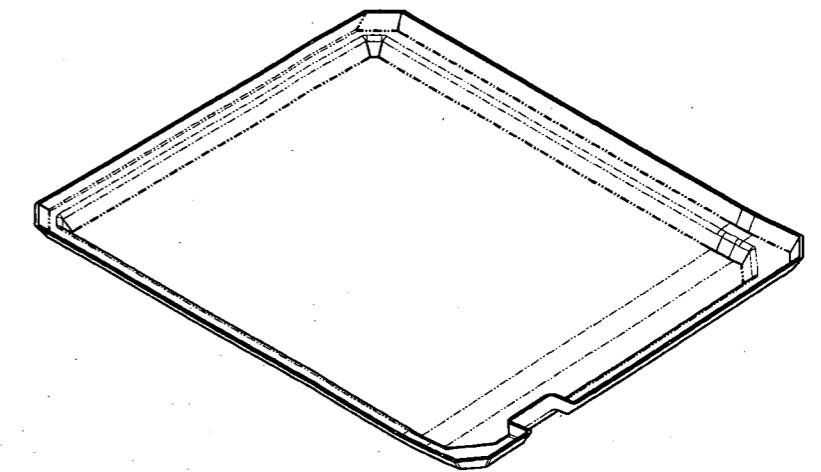
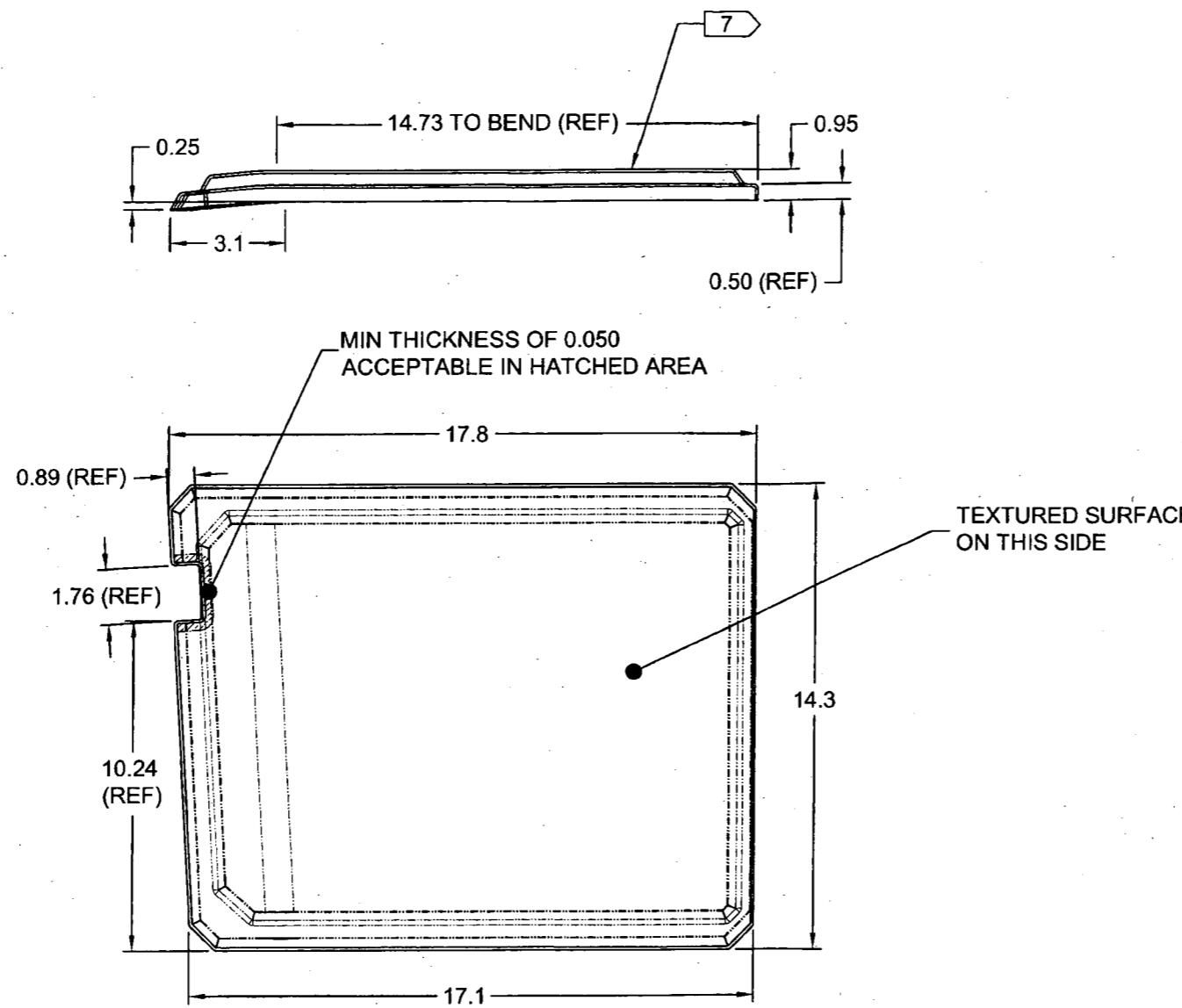
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DESIGN	Q	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	P4	
CHECKED		DRAWING NO.
MFG. APPR.		D3281
APPROVED		REV. D
DE APPR.		SHEET 2 OF 4
DATE	08.03.28	TITLE
		SCALE
		NTS
		FLOOR PROTECTOR
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8 7 6 5 4 3 2 1

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D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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08-04-11 MHD

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DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	44	
CHECKED	15	DRAWING NO. D3281
MFG. APPR.	10	REV. D SHEET 3 OF 4
APPROVED	10	TITLE FLOOR PROTECTOR
DE APPR.	10	SCALE NTS
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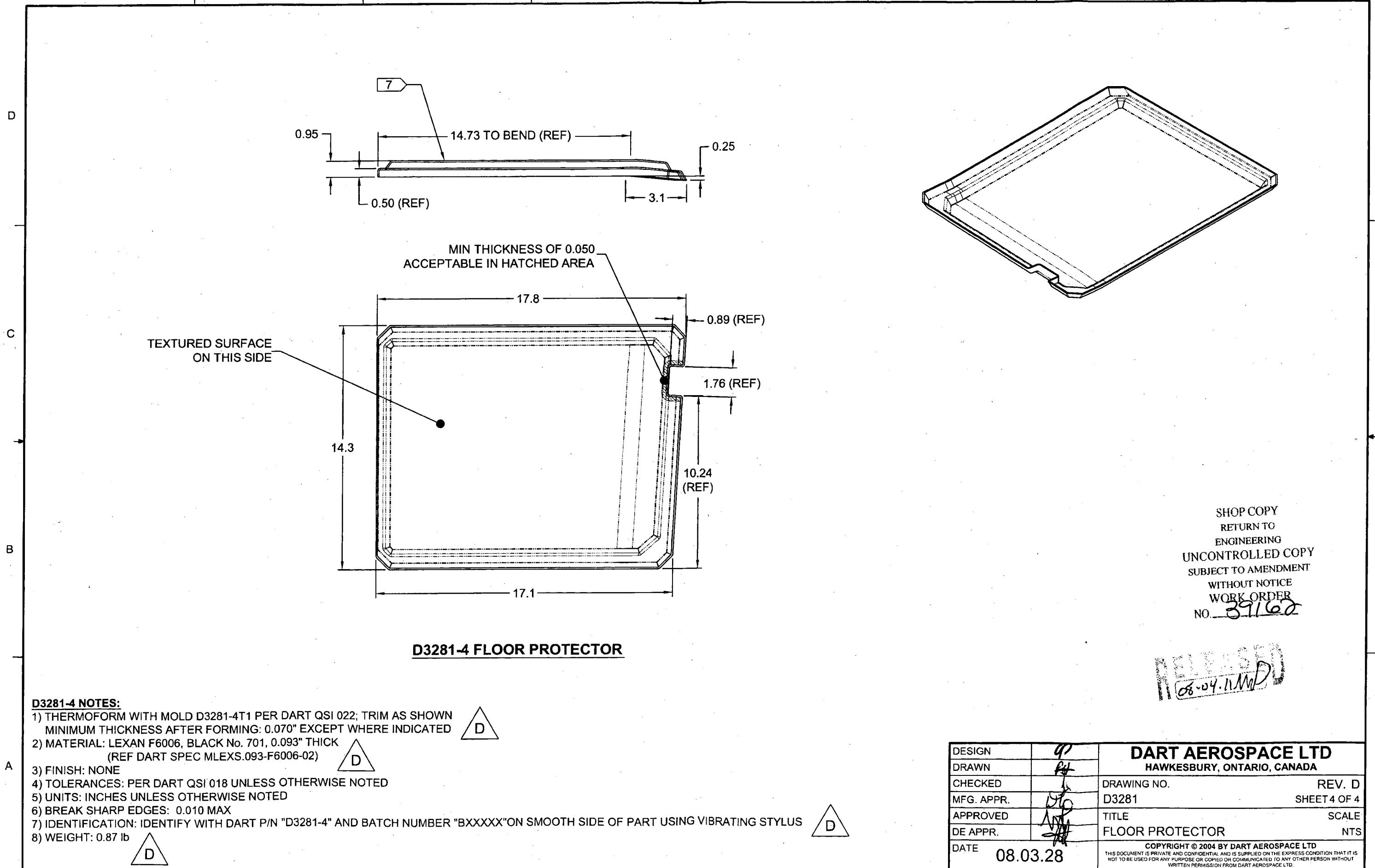
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